

Application No. 09/942,250
Amendment dated
After Final Office Action of October 19, 2005

Docket No.: 60680-1187

AMENDMENTS TO THE CLAIMS

1. (Currently Amended) A method for manufacturing an insert for a combustion head gasket comprising the steps of: (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower section defining a cavity adapted to receive a blank metal substrate; (b) placing said blank metal substrate into said cavity; (c) closing said upper mold section against said blank metal substrate to hold said blank metal substrate in place under a first applied force; (d) applying a second force greater than the first force to bend a portion of said blank metal substrate such that the orientation of at least one finger extending from said blank metal substrate relative the blank metal substrate is changed; (e) supplying elastomeric material to selected predetermined portions of said blank metal substrate; and (f) curing the elastomeric material.

2. (Original) The method of claim 1 wherein said insert is adapted to seal an engine oil flow aperture of said combustion head gasket, said blank metal substrate including a body portion adapted for registration with the oil flow aperture.

3. (Cancelled)

4. (Previously Presented) The method of claim 3 wherein said insert is manufactured in a single mold process that includes said shaping of said blank metal substrate and said molding of said bead.

5. (Previously Presented) The method of claim 4 wherein said elastomeric sealing bead bonded to said blank metal substrate comprises a sealing portion disposed about a peripheral edge of said blank metal substrate of said insert.

6. (Currently Amended) The method of claim 5 wherein said step of supplying includes supplying the elastomeric material ~~said sealing bead~~ to form a closed loop, and wherein said insert further comprises radially extending arms provided for attachment of said insert to the combustion head gasket.

7. (Previously Presented) The method of claim 6 wherein said second force forms at

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least one offset elbow.

8. (Original) The method of claim 7 wherein said elbow provides a connection between said arm and a shoulder portion of said insert, wherein said shoulder portion is contiguous with said peripheral edge of said closed loop portion of said insert.

9. (Original) The method of claim 8 wherein said closed loop is generally non-circular.

10. (Original) The method of claim 9 wherein said mold apparatus comprises die inserts for forming said insert.

11. (Currently Amended) A method for manufacturing a combustion head gasket comprising the steps of:

- (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower mold section defining a cavity for selectively receiving a blank metal substrate;
- (b) placing said blank metal substrate into said cavity;
- (c) closing said upper mold section against said blank metal substrate to hold said blank metal substrate in place under a first applied force;
- (d) applying a second force greater than said first force to shape said blank metal substrate, wherein said blank metal substrate is shaped by bending portions of said blank metal substrate such that the orientation of at least one of a plurality of fingers that extend from said blank metal substrate relative another one the plurality of fingers is changed;
- (e) supplying an elastomeric material to selected predetermined portions of said blank metal substrate; and
- (g) inserting said fingers into apertures formed within the gasket.

12. (Previously Presented) The method of claim 1, wherein said predetermined portions

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of said metal substrate include opposing, generally planar outer surfaces, and said elastomeric material extends away from said outer surfaces.

13. (Currently Amended) A method for manufacturing an insert for a combustion head gasket comprising the steps of:

- (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower mold section defining a cavity for selectively receiving a blank metal substrate;
- (b) placing said blank metal substrate into said cavity;
- (c) closing said upper mold section against said blank metal substrate to hold at least a portion of said blank metal substrate in place under a first applied force;
- (d) applying a second force greater than said first force to shape at least a section of said blank metal substrate; and
- (e) supplying an elastomeric material to selected predetermined portions of said blank metal substrate, wherein said predetermined portions of said blank metal substrate are not shaped by said second force.

14. (Previously Presented) The method of claim 1, wherein said step of supplying elastomeric material to selected predetermined portions of said blank metal substrate include supplying elastomeric material to opposing outer surfaces of said blank metal substrate.